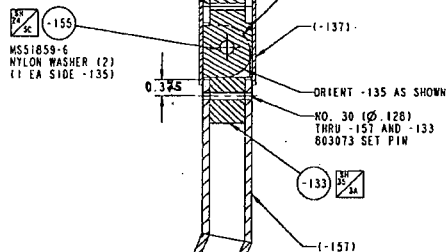


(CL-40-SBP-3 DETENT REF  
LOCATE AT INSTALLATION.  
SHOWN HERE FOR REF  
SEE DWG SH3 AND SH4)

(80373 SET PIN REF  
LOCATE AT INSTALLATION.  
SHOWN HERE FOR REF  
SEE DWG SH3 AND SH4)



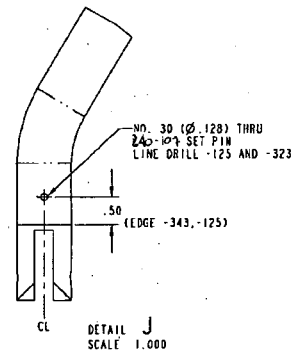
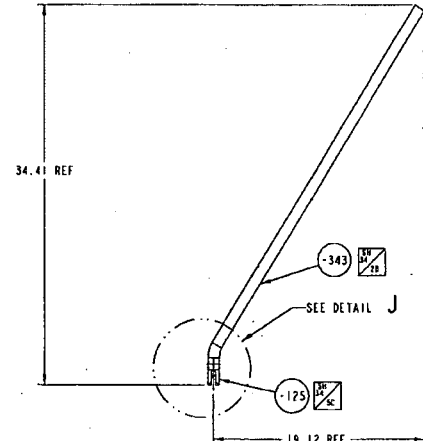
CR3213-4-2 RIVET  
(STOP FOR -137 SLEEVE)

1.875

**RELEASED**  
#06 of 20

**BASE ASSEMBLY** (SHOWN)  
(COMMERCIAL VERSION)  
SCALE 0.250

**BASE ASSEMBLY** (SAME, EXCEPT AS SHOWN)  
(CANADIAN VERSION)



**37 TUBE ARM ASSEMBLY**  
SCALE 0.200

**PREMIER AVIATION, INC.**  
2000 Aviation Parkway, Grand Prairie, Texas 75050  
D OSUV8 B67-43001  
SCALE: 15 OF 45

**60 SHORT T-HANDLE ASSEMBLY**  
SCALE 1.000

NO. 41384  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

**ORIGINAL**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 3:46:47 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 41384

Part Number: PB674300163

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 PB6743001133 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Clevis  
batch: 23994B x4

SS 08/10/08 (x4)

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg  
2- install spring slotted pin as per dwg

Pd 08.10.22 (x4)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23 (x4)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

Shore (x2)  
can welding S 08/10/23 (x4)

16.0 QC21 FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

08/10/23 (x4)

Job Completion



mf 08-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 3:46:47 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 41384

Part Number: PB674300163

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*\*mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat\*\*\*\*  
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15  
320°F  
3:45

M-L 08/10/03

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPRING SLOTTED PIN

batch:

17850 x4

STE 08/10/06 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:46:47 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT T-HANDLE ASSY
Job Number	: 41384		
Estimate Number	: 13529		
P.O. Number	:	Part Number	: PB674300163
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 40816	Material	:
Written By	:	Due Date	: 18/09/2008 Qty: <u>4</u> Um: Each
Checked & Approved By	: <u>JLD 08.8.18</u>		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product PB6743001-137 → B40023 → 4QTY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001131	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 Tube End Cap  
 batch: B41480

08.09.30 4

2.0	PB6743001129	Tube Handle
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Tube Handle  
 batch: B40019

08.09.30 4

3.0	PB6743001127	Handle Arm
-----	--------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Handle Arm  
 batch: B40018

5 stoc.

08.09.30 4

4.0	PB6743001157	Tube
-----	--------------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Tube  
 batch: B40026

08.09.30 4

5.0	CR321342	Cherry Rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Cherry Rivet  
 batch: M102569

08.09.30 4